



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBWSTI3327-1
Job Sheet 177853-A



Part No: RBWSTI3327-1

Job Qty: 1 ea

Part Name: Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/28/18

Job Tracking No:

Due Date: 6/18/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBWSTI3327 Rev. 1 IPP Rev. A 18.05.16 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	1 pcs		6/18/18	0.00	0.00	QC8 Machining-4		B.P 18-06-28
140	HandFinish	1 pcs		6/18/18	0.00	0.10	HandFinish7	DAS	
150	Outsource	1 pcs		6/18/18	0.00	0.00	Outsource13	AA	
190	Packaging	1 pcs		6/18/18	0.00	0.00	Packaging2	9-89	
200	QC	1 pcs		6/18/18	0.00	0.00	QC6		SP 18-06-28
210	Packaging	1 pcs		6/18/18	0.00	0.00	Packaging3-2		
220	QC21-SA	1 Ea		6/18/18	0.00	0.00	QC21		DAS 21 JUN 28 2018

Part Op 130 - 1-Engrave 23mm. using MARKTRONIC engraver Arial text height .25 as per DWG. note 2. 2-***NOTE*** heat treat Descriptions: not required as the wrench is already hardened.

140 - Bead blast remove chrome.

150 - -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK - Certificate of Conformity is required

Job BOM

Job BOM records could not be found.

508524

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 6/28/18 11:02 AM dart.lacelle.linda



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RBWSTI3327-1
Job Sheet 177853



Part No: RBWSTI3327-1

Job Qty: 6 ea

Part Name: Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/18/18

Job Tracking No:

Due Date: 6/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBWSTI3327 Rev. 1 IPP Rev. A 18.05.16 new issue DP Verify DD

Ship Via:

6/5

7-02

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		6/18/18	0.00	0.00	Start Up Machining-2		
110	Mill Conv	6 pcs		6/18/18	0.00	1.50	Mill Conv 2		
120	QC	6 pcs		6/18/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs		6/18/18	0.00	0.00	QC8 Machining-4		
140	HandFinish	6 pcs		6/18/18	0.00	0.60	HandFinish7		
150	Outsource	6 pcs		6/18/18	0.00	0.00	Outsource13		
190	Packaging	6 pcs		6/18/18	0.00	0.00	Packaging2		
200	QC	6 pcs		6/18/18	0.00	0.00	QC6		
210	Packaging	6 pcs		6/18/18	0.00	0.00	Packaging3-2		
220	QC21-SA	6 Ea		6/18/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. 2-Remove factory markings (7/8) as per DWG note 3. ***SNAP ON can stay*** 3-Deburr
Descriptions: 130 - 1-Engrave 23mm. using MARKTRONIC engraver Arial text height .25 as per DWG. note 2. 2-***NOTE*** heat treat not required as the wrench is already hardened.
140 - Bead blast remove chrome.
150 - -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
VS28B	Wrench	6 Ea (1 ea)	90-Start up Operation	S076519

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	VS28B	6	7	0

GAISS

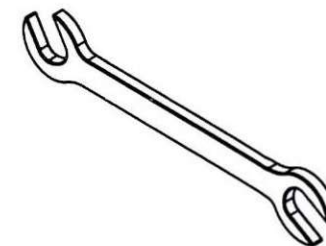
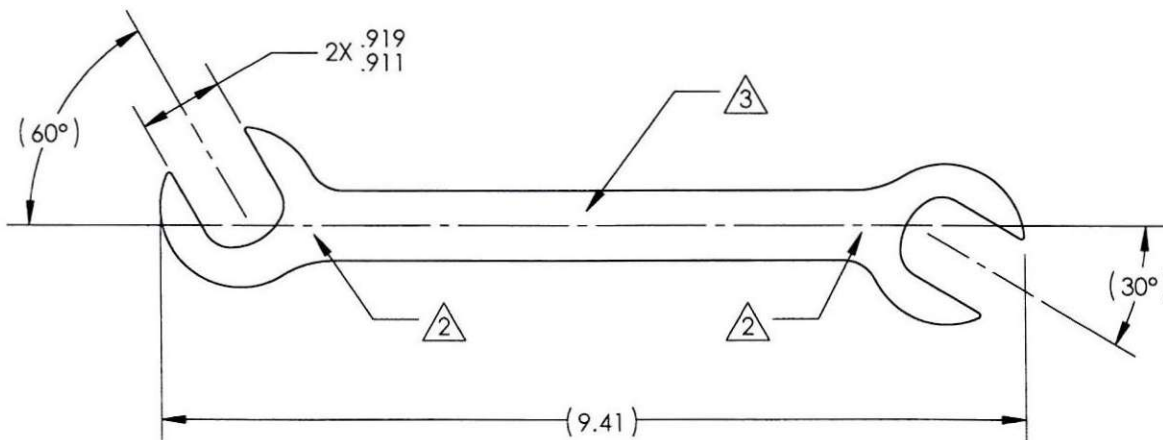
Part Specifications

Specifications could not be found.

Plex 6/7/18 3:59 PM dart.logan.david

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



NOTE:

1. USE PDF FOR ENGRAVING.
2. ENGRAVE 23MM ARIAL TEXT HT. .25
3. REMOVE ALL FACTORY MARKINGS.

(-1)
WRENCH

DART AEROSPACE																									
TITLE TOOL KIT, SPECIAL WRENCHES																									
DWG NO. RBWSTI3327-1	REV 1																								
<table border="1"> <tr> <td>MAT'L STEEL</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT RC 40-50</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH ZINC PLATE</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC ASTM B633 TYPE I SC 2</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125</td> </tr> <tr> <td>DRAWN BY: RJC 05/09/2017</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: DD 05/09/2017</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: AA 05/10/2017</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: JL 05/24/2017</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: JAG 06/01/2017</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td></td> <td>USED ON MODEL</td> </tr> <tr> <td></td> <td>AW139</td> </tr> </table>		MAT'L STEEL	UNLESS OTHERWISE SPECIFIED	HEAT TREAT RC 40-50	DIMENSIONS ARE IN INCHES	FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8	SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125	DRAWN BY: RJC 05/09/2017	1. BREAK ALL SHARP EDGES	CHECKED: DD 05/09/2017	.015 x 45° OR .015R	OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY	QA APPR: JL 05/24/2017	AFTER PLATING	APPROVED: JAG 06/01/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		USED ON MODEL		AW139
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SHEET 2 OF 2																									

DART AEROSPACE LTD		Work Order:	77857
Description: WRENCH		Part Number:	RRWST13327-1
Inspection Dwg: Same as P/N	Rev: 1	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	1/5/21	Checked by:	De	QC Inspector:	
Date:	18/6/19	Date:	18-06-28	Date:	

Checked by:	He
Date:	18-06-28

QC Inspector: _____
Date: _____

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Date:

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>177853-A</u> Part No. <u>BBWSTI3327-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :		MRB (QSI042) Approval <i>MLa</i> <u>JUN 28/18</u>																			
Description Work Order Deviation				Disposition																					
BBWSTI3327-1 HAS NOT BEEN SENT FOR PAINTING. QTY (1) PART				THIS DEVIATION IS ACCEPTABLE IF THE SURFACE IS POLISHED TO A MIRROR FINISH.																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
QC / QA Coordinator Approval																									

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :					
Misidentified ☐	☒ Past Due						